Work Orde January 18, 201	er ID 65489 1 3:12:59 PM									Page 1
Item ID: Revision ID:	D3475-1		Accept				S	etup Star		
Item Name:	Outlet Adapter Plate							Sto	р	
Start Date: Required Date: Reference:	1/18/11 Start Qty: 3.00 1/31/11 Req'd Qty: 3.00	4100100 11111		Cust Item I Customer:	D:					
Approvals:	Process Plan: CL	Date:\ _\0\			ate:		R	kun Star Sto		
	QC:	Date:	SPC (Y/N):	Da	ate:			•		
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr					-				
D3475	Rev C									
	FLOW WATER JET		0.00				IR 11-	1-76		
Waterjet FLOW CNC Waterje 304 . 01 %	Dwg Rev Prog Rev	per Dwg D3475	0.00				11 64		¥)

0.00

0.00

110

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRC	CEDURE CHAN	GE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								V	
							,		
								· · · · · · · · · · · · · · · · · · ·	
Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	No DQA :		Date: _	
		esolution:							
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NCR)			<u>, , , , , , , , , , , , , , , , , , , </u>
DATE	STEP	Description of NC	ļ		tion B	Verifica		Approval	Approval
DAIL		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	1 C	Chief Eng	QC Inspector
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		·						#	
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	1				- 1	1			

January 18, 2011 3:12:59 PM

Item ID:

D3475-1

Revision ID: Item Name:

Outlet Adapter Plate

Start Date:

1/18/11

Start Qty: 3.00

Required Date: 1/31/11

Req'd Qty: 3.00



Date:

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Accept

SPC (Y/N):

Tooling:

Run Hours

Set Up/

Jul01/76

Tool ID

Date:

Date:

Tool # Plan Code

Accept Qty

Reject Qty

Run

Setup Start

Stop

Start

Stop

Reject Number Stamp

Insp.

Work Center ID

120

Sequence ID/

Quality Control

Operation Description

QC8- Inspect parts - second check

Memo

0.00

0.00

0.00



Small Fab Small Fab

130

Small Fab

Memo

Memo

1-Deburr if necessary.

2-Form as per Dwg D3475 using Dt8847 A&B on press.

140

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

W/O:	•	·	WO	RK ORDER CHANGI	ES	•			
DATE	STEP	PRO	CEDURE CHAI		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A:	Date: _	
	R	esolution:	Dispositio	n:	_ QA: N/C CI	osed:		Date: _	
NCR:		\	WORK ORDI	ER NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC		Corrective Action Section		Verific		Approval	Approval
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti	on C	Chief Eng	QC Inspector
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		t							

Work Order ID 65489



Page 3

January 18, 2011 3:12:59 PM

Required Date: 1/31/11

Item ID:

D3475-1

Accept



Setup Start

Stop



Revision ID:

Item Name:

Outlet Adapter Plate

Start Date:

1/18/11

Start Qty: 3.00

Req'd Qty: 3.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Date: **Tooling:**

SPC (Y/N):

Set Up/

Run Hours

Date: Date:

Start Run



Stop

Sequence ID/ **Work Center ID**

150

Packaging

Operation Description

Identify as per dwg & Stock Location: 05

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

Packaging

160

Quality Control

QC21- Final Inspection - Work Order Release

Memo

Memo

0.00

0.00

W/O:			W	ORK ORDER CHANG	ES			
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			÷					
·								
Part No		PAR #:	Fault Cat	egory:	NCR: Yes	No DQA :	Date: _	
	R	esolution:	Dispositi	on:	_ QA: N/C Cld	osed:	Date: _	
NCR:			WORK ORI	DER NON-CONFORM	ANCE (NCR)		
DATE	STEP	Description of NC Section A	Initial	Corrective Action Sec Action Description	tion B Sign &	Verification Section C	Approval Chief Eng	Approval QC Inspector
		Section A	Chief Eng	Chief Eng	Date	Jection 0	Orner Eng	QO moposion
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	1	j						
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Picklist Print

January 18, 2011 3:12:59 PM

Work Order ID: 65489

Parent Item: D3475-1

Parent Item Name: Outlet Adapter Plate



Start Date: 1/18/11

Required Date: 1/31/11

Page 1

Start Qty: 3.00

Required Qty: 3.00

Comments:

IPP Rev:A

New Issue 06-02-02 JLM

IPP Rev:B As per Rev B 06-05-24 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S26GA		Purchased	No			100	sf	109.6600	` 0.08	0.24	135		
											B1-1-2)6	····

304/316 0.018 SHEET

Location	Loc Qty	Loc Code	
MAT20	109.66		
109398	20.06		
112885	89.6		113885



W/O:			WC	ORK ORDER CHANGES)				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								Prod Wigi	· · · · · · · · · · · · · · · · · · ·
		•							
Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DG	A:	Date: _	
	Re	esolution:	Dispositio	n:	QA: N/C CI	osed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORMAN	CE (NCF	R)	· · · · · · · · · · · · · · · · · · ·		
DATE	OTED	Description of NC		Corrective Action Section		Verif	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Sec	tion C	Chief Eng	QC Inspector
						:			
					•	-			
L								:	

DART AEROSPACE LTD	Work Order:	6 5489
Description: Outlet Adapter Plate	Part Number:	D3475-1
Inspection Dwg: D3475 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

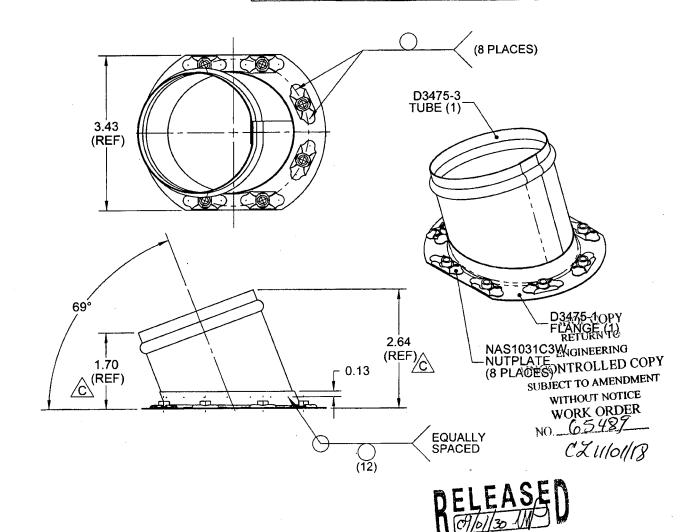
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.239	+/-0.010	2.738	i de		V B02	
2.055	+/-0.010	2,057	\ <u></u>		ν	
Ø3.250	+/-0.010	3.748	7		V	
Ø4.00	+/-0.030	4.002	×		V	
Ø0.250	+0.005/-0.001	.253	>		Ý	
0.018	+/-0.010	.09	≫		V	
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Measured by:	Audited by:	Preliminary Approval:
Date: 11-1-36	Date: Idoi/20	Date:

Rev	Date	Change		Revis	ed by	7.00.0104
Α	10.10.25	New Issue	·	KJ •	KX	



DES	IGN	DRAWN BY	DART AERO HAWKESBURY, C	SPACE LTD DITARIO, CANADA
CHE	CKED	APPROVED	DRAWING NO. D3475	REV. C SHEET 1 OF 7
DAT	_	12.19	DUMP OUTLET	SCALE 1:2
Α	0	6.01.24	NEW ISSUE	
В	0	6.05.16	REDESIGN D3475-1F/-5/	/-7S/-7; ADD D3475-9
С	0	8.12.19	CORRECT DIMS PER D347 HOLES ON D3475-7; MATL	75-3F; REMOVE Ø 0.191 . SPEC WAS MIL-S-5019



D3475-041 DUMP OUTLET

NOTES:

- 1) SPOT WELD PER DART QSI 004 2) IDENTIFY WITH DART P/N D3475-041 USING FINE POINT PERMANENT INK MARKER
- 3) FINISH: NONE
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 5) ALL DIMENSIONS ARE IN INCHES
 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

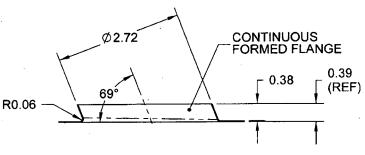
QTY -041	P/N D3475-041	DESCRIPTION DUMP OUTLET	
Х			
1	D3475-1	FLANGE	
1	D3475-3	TUBE	
8	NAS1031C3W	NUTPLATE	

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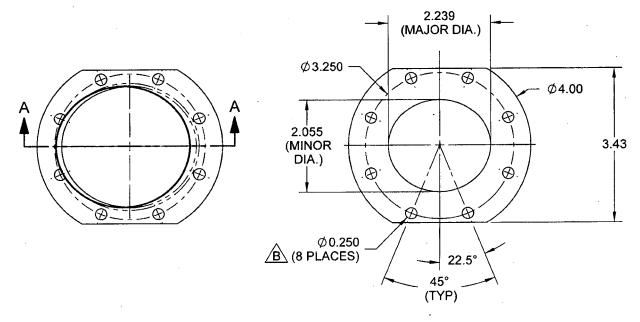


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	D3475	REV. C SHEET 2 OF 7
DATE 08.12.19		DUMP OUTLET	SCALE 1:2



SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 65489

SECTION A-A



D3475-1 OUTLET

D3475-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 3) ALL DIMENSIONS ARE IN INCHES 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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